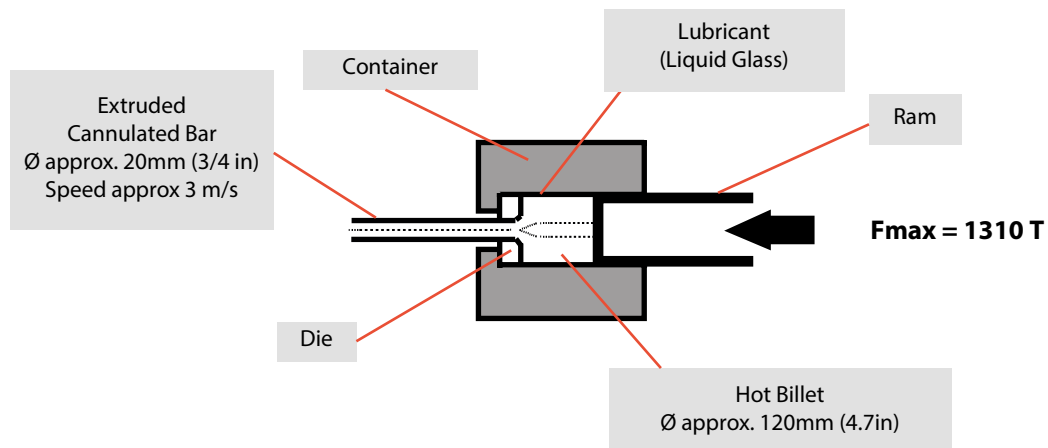


INDUSTRY EXTRUSION PROCESS FOR HOLLOW BARS

EXTRUSION PROCESS LAYOUT

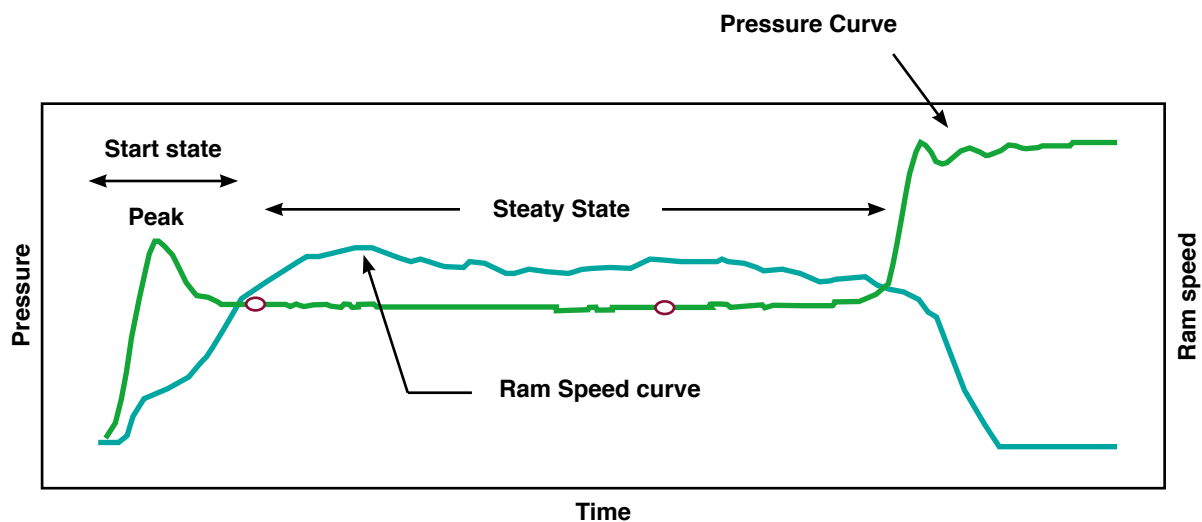


Temperatures

- Titanium Alloys $\approx 920^{\circ}C$ (1688 $^{\circ}F$)
- Stainless Steels $\approx 1120^{\circ}C - 1160^{\circ}C$ (2048 $^{\circ}F - 2120^{\circ}F$)

During extrusion TIME, SPEED, TEMPERATURE and PRESSURE are supervised with a specific acquisition system which analyses each and every billet.
Typical curves are shown hereafter.

PRESSURE AND RAM SPEED IN RELATION TO TIME DURING AN EXTRUSION OPERATION



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